

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011608**Date Inspected:** 27-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

6CE

Shield Metal Arc Welding (SMAW) repair welding was performed on X35 and X8E stiffeners located at cross beam side of segment between panel point 45 & 46. Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and WR 10057 repair procedure.

6BE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 007 and 010 located at LD015A-001 on cross beam side of segment between panel point 43 & 44. Welder is identified as Mr. Hao Jianxiang (067665). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1, WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR 10381 repair procedure.

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6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 007 and 010 located at LD016A-001 on cross beam side of segment between panel point 43 & 44. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1, WPS-345-SMAW-4G (4F)-FCM-Repair-1 and WR 10380 repair procedure.

7BE

Flux Core Arc Welding (FCAW) welding was performed on weld joints 43 and 44 located at SP532-001 bike path side of segment. Welder is identified as Mr. Dian Yifa (068596). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2132.

NDT Observation

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Y location and indications are as followed:

5CE

1. Longitudinal Diaphragm web plate insert on bike path side of segment on the bike path side of segment between panel point 35 and 36.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

7BE+7CE

1. Back gouge of bottom plate weld splice OBE7C-008.

Note:

Due to inclement weather, work was limited in the OBG Trail Assembly Yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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